



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-616-011
Job Sheet 176216



Part No: D350-616-011

Job Qty: 1 ea

Part Name: Full Emergency Litter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV H IPP E 03.04.04 Reformat KJ/RF IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP
REV:G 13.05.21 AS PER DWG REV.G DD VERF:JLM IPP REV:H 16.04.19 NOW @ CHG007 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/21/18	5/21/18	0.00	0.00	Start Up Small Fab-4		MLC
101	Small Fab	1 pcs	5/21/18	5/21/18	0.00	0.65	Small Fab-4		MLC DAS 38
105	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		38
119	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging1-3		Smbs 1-89
120	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC4		12/1/20
125	DC	1 pcs	5/21/18	5/21/18	0.00	0.00	DC		5
130	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	5/21/18	5/21/18	0.00	0.00	QC21		
150	QC21-FG	1 Ea	5/21/18	5/21/18	0.00	0.00	QC21		DAS 21 MAY 09 2018

Part Op 101 - 1- Assemble as per Dwg D2370 2- Transfer drill using D4812-041 as template and open to size 0.250" as per Dwg
Descriptions: D2370 AND DT9935 DRILL JIG 3- Ensure fit of D4812-041 and remove for shipping ***D4812-041 MUST STAY WITH
LITTER FRAME*** 4- Deburr

125 - Photocopy bluefile and create labels per PPP D350-616-011 CHG007

130 - Identify and pack for shipping as per PPP D350-616-011 Location: F9039 PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2370-1	Litter Frame Assembly <i>st 641</i>	1 Ea (1 ea)	90-Start up Operation	<i>5068239</i>
D4812-041	Patient Stop Assembly <i>st 208</i>	1 Ea (1 ea)	90-Start up Operation	<i>5051951</i>
D350-616-013	Deck Plate & Tie Down	1 Ea (1 ea)	119-Packaging	<i>5069511</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2370-1	1	3	0
	D4812-041	1	5	0
119-Packaging	D350-616-013	1	2	0

Part Specifications

Specifications could not be found.



Container No: S069078



Part: D350-616-011

Job No: 176216

Serial No/Batch: S069078

Revision:

Inspector:

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 05/07/18

4. 1

PAGE 1 OF 1

Part Number: D350-616-011

Description: EMERGENCY LITTER

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																										
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																						
								Lead hand / Supervisor Approval Verification																																																						
								QC / QA Coordinator Approval																																																						
Root Cause		FAULT CATEGORY																																																												
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Cut Too Short ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Drill Holes ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																													

REFERENCE ONLY

QTY - 011	QTY - 013	QTY - 015	Part Number	Description
X			D350-616-011	Emergency Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370-1	LITTER ASSEMBLY
1			D4812-041	PATIENT STOP ASSY (REPLACES D2493)
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D4780-041	FWD COVER MOUNTING BRACKET ASSY
		1	D5387-041	AFT COVER MOUNTING BRACKET ASSY (REPLACES D4779-041)
		1	D5388-1	STUB COVER (REPLACES D4778-1 AND D3494-1)
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		7	MS35207-263	SCREW
		13	NAS1149D0363J	WASHER (or AN960JD10)

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 16.03.11
CERT. NO.: SH96-10
ISSUE NO.: 3

H	D5387-041 AND D5388-1 WERE D4779-041 AND D4788-1; REVISED SHT 3; ADDED TRIM NOTE ON SHEET 10. REASON: PAR15-415 AND PAR15-467.	MB	16.03.11
G	D4812-041 PATIENT STOP ASSY WAS D2493 (SH1), UPDATE WEIGHT AND BALANCE TABLE (SH2), NEW PART/ FIGURE (SH7), REVISE FIGURE (SH 9), ADD OPTION APPLICABILITY NOTE (SH11)	DB	13.04.01
F	REPLACE MMS-D350-616 REF. WITH ICA-D350-616 INCORPORATE DSI 9645	DC	13.03.01
E	MAKE DSI 9310 STANDARD, D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	N/A	D350-616	SHEET 1 OF 13
APPROVED		TITLE	SCALE
DE APPR.		AS 350/355 LITTER KIT INSTALLATION	NTS
DATE	16.03.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	